

SOLICITATION AMENDMENT



I. AMENDMENT

SOLICITATION NO.	SOLICITATION DATE	AMENDMENT NO.	AMENDMENT DATE
267456	6/02/2014	01	6/10/2014
ISSUED BY AND RETURN TO: Washington River Protection Solutions, LLC P.O. Box 850 Richland, WA 99352 Michael_W_Voss@rl.gov		DUE DATE This amendment does not change the date by which offers are due unless a date and time is inserted below.	
		DATE	TIME

DESCRIPTION OF AMENDMENT

Vendor Question for Solicitation 267456 NDE And Machining of Spare Purex Parts

1. Will all of the minimum quantities of components to be inspected or finish machined listed in Tables 3-1 and 3-2 be shipped to the subcontractor location in one lot, or do we need to assume that we may be performing each piece one at a time?

Each "Item" group in Tables 3-1 and 3-2 should be assumed to be handled/shipped individually.

2. Related to shipping of components, is WRPS interested in receiving bids from companies outside the tri-cities?

WRPS will accept proposals from vendors outside the Tri-Cities.

3. We can demonstrate experience machining various connectors for nuclear applications, but we cannot demonstrate experience machining PUREX connectors per 12.0 in the SOW, is this acceptable to WRPS?

Having experience is essential for this contract, vendors are advised to explain in detail their machining experience.

4. SOW Requisition #267456, Section 3.2 states: "Items 4, 5, and 6 of Table 3-2 shall be machined from...material procured by the subcontractor..." However, Table 3-2 identifies "Parts and Quantities to Machine" from WRPS' inventory, with fabrication of Gasket Retainers {Items 5, and 6} requested to be "...priced as an option." The question is: Does WRPS provide Item 4 {3" Split Washer} from their inventory so that we can perform machining/inspection/testing, or do we procure material in order to fabricate/inspect/test Item 4?

WRPS does not provide Item 4, this material shall be procured by the subcontractor.

5. RPP-PLAN-57325 (REV.0), Section 2.10.2 states: "The test fixture shall use a PUREX gasket on the sealing face." The question is: Does WRPS supply these gaskets in order for us to perform the hydrostatic pressure test, or do we have to machine/fabricate/purchase these gaskets in order to perform the hydrostatic pressure test? Further, are these gaskets a re-usable item or will we need a new gasket for each of the 22 hydrostatic pressure tests requested?

WRPS will provide gaskets, gasket retainers, and skirts as needed to support fabrication of the hydrostatic test fixture. The gasket should be good for the testing duration, however there are

plenty of gaskets available in the event damage occurs during testing.

6. We assume we will be provided all raw materials except for the gaskets – please confirm.

See response to question 2: WRPS will support with test fixture components as much as possible.

7. Any implied schedule requirements? (Award date? Finish date?)

The project is in the middle of processing PUREX parts for upgrade, it is anticipated that the first batch of parts for testing will be available approximately 4 weeks after contracted is finalized. Please use an award date of June 23, 2014. The contract will be complete by the end of FY14 (Sep. 30).

8. Solicitation states hold points, but SOE says none – please confirm which applies?

There are no hold points associated with this contract.

9. Solicitation states 100% dimensional inspection, but RFP-PLAN-57325 indicates key dimensions for inspection – please confirm which is correct?

Items in Table 3-1 will follow the guidance of RPP-PLAN-57325, Items in Table 3-2 will be dimensionally inspected per the design media, if not specified in design media, than 100% DI is required.

10. Which parts do tolerance guidance in RPP-14541 apply to?

Table 3-1.

11. Does *modification to 2" horizontal gasket described in RPP-14541* retainer apply?

No.

12. On page 5 on the Solicitation it is stated "Please complete the attached compensation schedule.....". Is this the same as the "Unit Rate Price Proposal Form" found in Exhibit 1?

Yes, please submit exhibit one filled out with your proposal.

13. What is the magnetic particle test (MT) acceptance criteria?

3.3.2 Magnetic Particle Criteria

There shall be no cracks. There shall be no cold shuts or shrinkage defects whose measurable dimensions exceeding the following acceptance criteria.

The following indications are unacceptable:

Note: > = greater than < = less than

Linear Indications

> 1/16 (0.062) inch
> 1/8 (0.125) inch
> 3/16 (0.187) inch

Material Thickness

< 5/8 (0.625) inch
5/8 (0.625) inch
to < 2 inches
2 inches and greater

Rounded Indications

> 1/8 (0.125) inch
> 3/16 (0.187) inch

Material Thickness

< 5/8 (0.625) inch
5/8 (0.625) inch
and greater

Four or more indications in line separated by 1/16 (0.062) inch or less edge to edge.

Ten or more indications in any six square inches of surface with a major dimension of this area not to exceed six inches taken in the most unfavorable orientation relative to the indication being evaluated.

14. Are hardness testing indentations allowed to remain on the part?

Yes, the test should not be in a critical area of the part (near hook tip, hook pin hole, etc.).

15. Section 6.2 of the SOW specifies ASNT-TC-1A (**2011**) but Solicitation 267456 specifies ASNT SNT-TC-1A (**2001**) edition. Which one is correct?

2011.

16. **Inspection Test Plans will be submitted for review by...** NOTE: This statement, found in the next to last sentence of Para. 3.1 in the SOW, is incomplete. Please confirm.

...WRPS engineering.

17. Solicitation No: 267456 - Section 4.1.2 – Referenced Compensation Schedule – note that quantities listed do not match quantities listed in SOW. Can we confirm quantity to use if from Solicitation or SOW prior to submitting, or not be concerned and focus on accurate fixed unit cost due to sampling quantity variables?

Items 1-6 on the compensation schedule reflect the quantities of Inspections/Tests for table 3-1. Items 7-12 on the compensation schedule reflect the quantities machine for table 3-2. More focus should be placed on the fixed unit cost for each line item in the compensation schedule.

18. Solicitation No: 267456 - Section 10.6 – NDE specifying radiography which is not in SOW and not being planned for. This is probably carryover from previous RFP (copy). Please confirm.

At this time, there is no RT required as part of this contract.

19. Statement of Work No: 267456 - Section 6.2 Table for Applicable Standards – calls out ASNT-TC-1A-2011 (probably typo) does not align with Solicitation No: 267456 - Section 10.6 - NDE shall be qualified and certified to (ASNT) SNT-TC-1A-2001. Please confirm.

2011 is the correct revision.

20. Fabrication drawing instructs you to see material specification on another drawing that is not included in package provided by WRPS. Thus material specification is not available and additional drawing is required. Please confirm.

Please provide drawing number.

21. Can the period for submitting questions to WRPS be extended one business day to COB Monday, June 9?

No. Any exceptions and assumptions should be addressed on proposal.

22. The HWS and HS documents are old Hanford standards which we thought were cancelled years ago. Is this correct?

HS-BS-0071, HS-BS-0072, HS-BS-0073, HS-BP-0018 are still current.

23. Can the material be bar stock in place of billet or plate?

Yes, the material may be in any form. The drawing specifies the split washer as ASTM A582 416L and the gasket retainers as ASTM A276 316L.

24. We're trying to determine exactly what is the material that we're being asked to test by the Notes on the drawings:

H-2-32446 (Rev.16), General Note #1: Material ASTM-A296 Modified(?) in accordance with **HWS-10087**
The drawing is replaced by H-2-90185 and H-2-90186. H-2-32446 nozzles are made from ASTM A296-76 CD-4MCu, A296 is replaced by A743/A743M.

H-2-68214 (Rev.8), General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0072 ASTM A743, CF8.**

H-2-90185 (Rev.5), General Note #1: Material and Quality shall conform to the requirements of **RPP-11596 ASTM A995 Grade 1B, CD4MCuN.**

H-2-90174 (Rev.7), General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0071 ASTM A747, CB7Cu-1 or CB7Cu-2.**

H-2-68209 (Rev.8), General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0073 ASTM A148, 90-60**

H-2-68210 (Rev.10, General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0073 ASTM A148, 90-60**

H-2-68218 (Rev.9), General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0072 ASTM A743, CF8.**

H-2-90175 (Rev.7), General Note #1: Material and Quality shall conform to the requirements of **HS-BP-0071 ASTM A747, CB7Cu-1 or CB7Cu-2.**

25. Since we don't have access to these referenced documents we don't know what the material is. How can we find out?

Need: **ASME Specification B31.3 (2012) "Process Piping"**; per SOW.

- How can we access this?

Request documentation from Procurement Specialist.

Need: **Inspection-Test Plan {ITP}** (for all items listed in Table 3-1 of the SOW)

- How can we access this?

The ITP needs to be drafted as part of this contract.

Need: **Fabrication, Inspection & Test {FIT} Plan {Shop Traveler}** (for all items listed in Table 3-2 of the SOW).

- How can we access this?

The FIT needs to be drafted as part of this contract.

Need: **hydrostatic test fixture** {design/fabricate/assemble/test}

- Pump
- Calibrated gauge
- Proper hoses
- High-pressure fittings
- Fixturing
- Safety considerations
- Procedure

Subcontractor shall supply all necessary equipment to preform hydrostatic test in their facility.

Except as provided herein, all terms and conditions of the solicitation remain unchanged and in full force and effect.

II. ACKNOWLEDGMENT OF AMENDMENT

Offerors must acknowledge receipt of this amendment in writing, by the date and time specified for proposal submissions or the revised Due Date above (if revised), whichever is later. FAILURE OF YOUR ACKNOWLEDGMENT TO BE RECEIVED AT THE DESIGNATED LOCATION BY THE SPECIFIED DATE AND TIME MAY RESULT IN REJECTION OF YOUR OFFER. If, by virtue of this amendment you wish to change your offer, such change must make reference to the solicitation and this amendment.

NAME AND ADDRESS OF OFFEROR	NAME OF SIGNER
	TITLE OF SIGNER
	DATE
OFFEROR (Signature of person authorized to sign)	